

Work Order ID 157508

Monday, March 20, 2017 1:14:45 PM

157508

Page 1

Item ID: D3912-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Eyebolt Block
Start Date: 3/21/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/28/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 9-89 Date: MAR 20 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3912	B

100	Cut blanks as per folio	0.00
-----	-------------------------	------

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 2.50" LONG

0.33

12 6

DAS
49
9-89

17/03/26

110

0.94

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA870 AND DWG

FOLIO REV: AADWG REV: B

DEBURR

2.62

12 8

DAS
14
9-89

17/03/26

ML
17/03/27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.12				12	0		DAS 14 9-89 17/03/28 HL 17/03/27
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.24				12	0		DAS 32 9-89 17-03-28
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>91 658</u> Memo	0.00 1.20				12	0		DAS 6 9-89 MAR 29 2017

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OTHER :					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	1.20							
Quality Control									



MAR 29 2017

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Work Order update only ☐

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OTHER : _____					

Picklist Print

Monday, March 20, 2017 1:14:48 PM

Page 1

Work Order ID: 157508

157508

Parent Item: D3912-3

D3912-3

Parent Item Name: Eyebolt Block

Start Date: 3/21/2017

Required Date: 3/28/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	16.7150	0.208	2.627368			
M303B1 000X1 000									**				
303 BAR 1" X 1"													

DAS
49
9-89

17/03/20

Location

MAT008

m136463

m136896

Loc Qty

16.715

3.915

12.8

Loc Code

2.58

DQA: _____ Date: _____

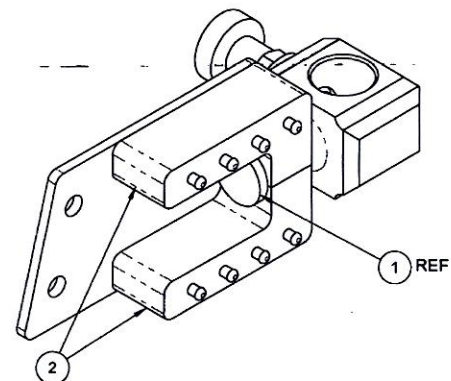
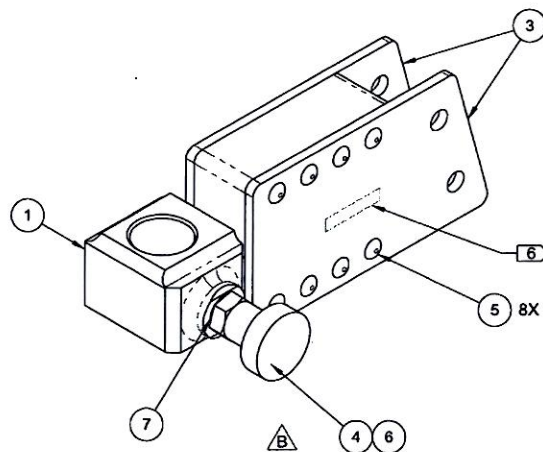
WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____					

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157508 MJS
17-03-20

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

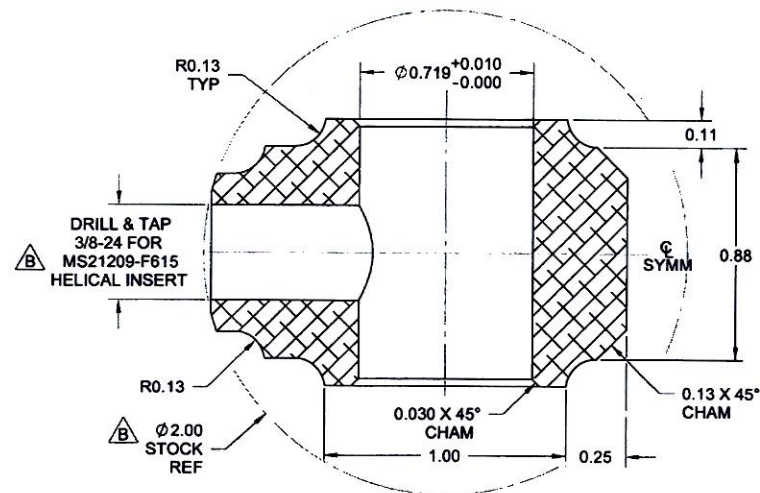
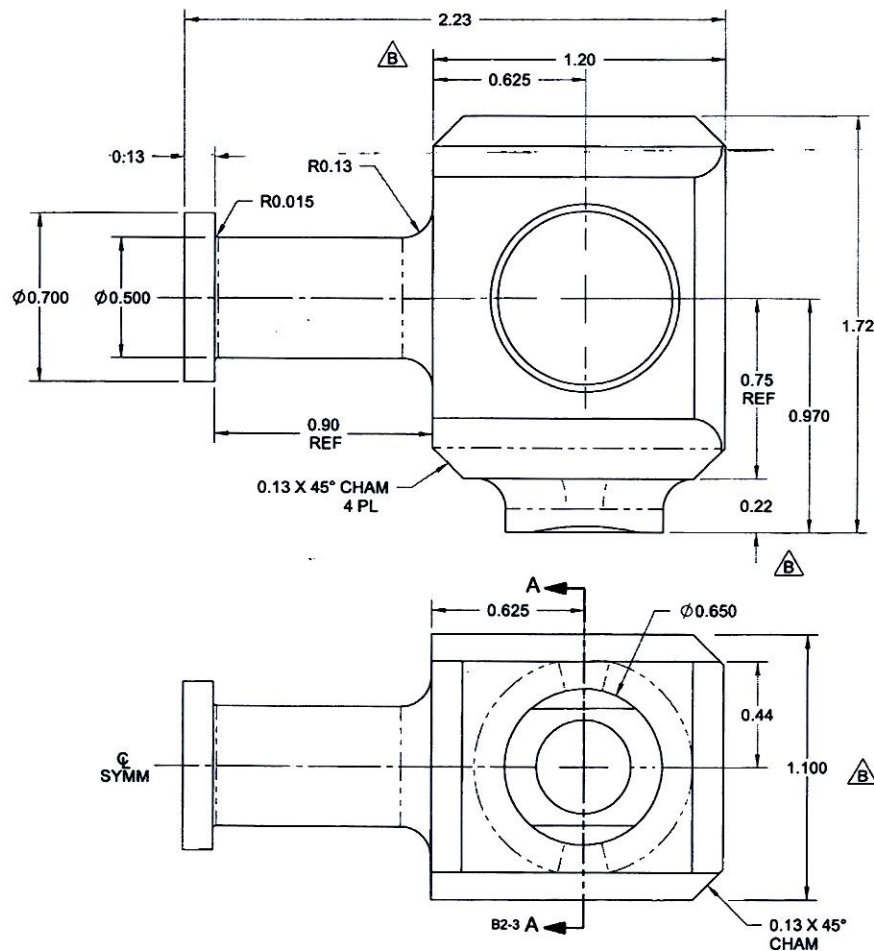
- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1.5		
DRAWN	1.5		
CHECKED	1.5		
MFG. APPR.	1.5		
APPROVED	1.5		
DE APPR.	1.5		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3912
TITLE EYEBOLT RECEIVER ASSY
REV. B
SHEET 1 OF 3
SCALE NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.



SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

DESIGN	ASS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	81	DRAWING NO.	REV. B
CHECKED	81	D3912	SHEET 2 OF 3
MFG. APPR.	81	TITLE	SCALE
APPROVED	81	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	81	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
 -5: 0.24 lbs

RELEASE
2010-07-16

DESIGN	<i>A/S</i>	DART AEROSPACE LTD	
DRAWN	<i>8</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>8</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>8</i>	D3912	SHEET 3 OF 4
APPROVED	<i>8</i>	TITLE	SCALE
DE APPR.	<i>8</i>	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	